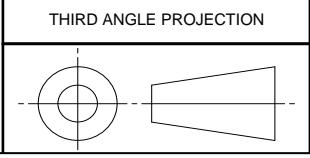


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REV. C		FEDERAL SUPPLY CLASS 5306	
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CUSTODIAN: E-25			
	AEROSPACE STANDARD BOLT, MACHINE - STEEL, CADMIUM PLATED, HEXAGON HEAD, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A	AS9518	REV. C

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ISSUED 1999-08 REAFFIRMED 2006-05 REVISED 2007-09 STABILIZED 2015-06

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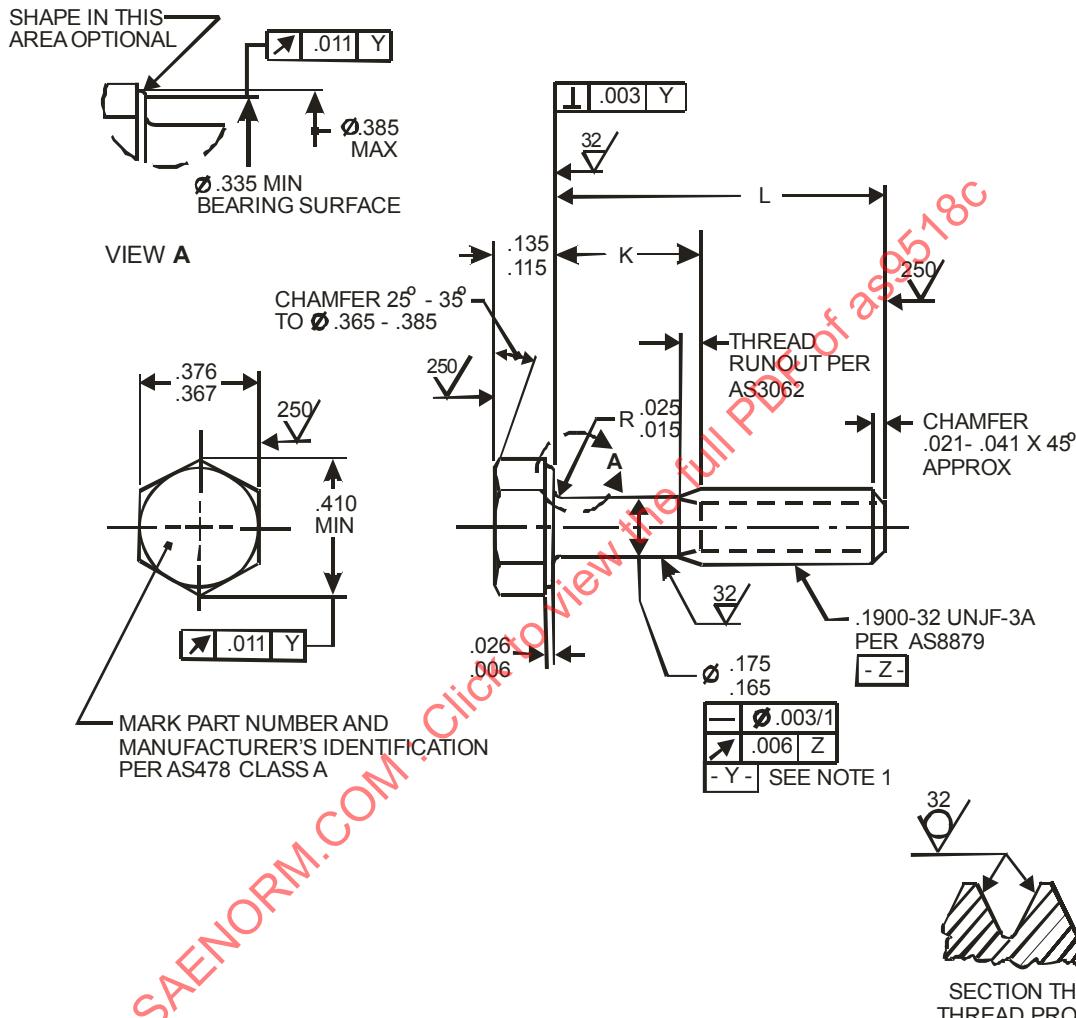


FIGURE 1 - BOLT

TABLE 1 - PART NUMBERS AND DIMENSIONS

PART NO.	L	K	APPROX. MASS LB/100	PART NO.	L	K	APPROX. MASS LB/100
MS9518-04	.365-.385	.072-.092	.66	MS9518-24	1.615-1.635	.935-.995	1.47
MS9518-05	.428-.448	.072-.092	.70	MS9518-25	1.678-1.698	.998-1.058	1.51
MS9518-06	.490-.510	.072-.092	.74	MS9518-26	1.740-1.760	1.060-1.120	1.55
MS9518-07	.552-.572	.072-.092	.78	MS9518-27	1.865-1.885	1.185-1.245	1.63
MS9518-08	.615-.635	.072-.092	.82	MS9518-28	1.990-2.010	1.310-1.370	1.71
MS9518-09	.678-.698	.072-.092	.86	MS9518-29	2.115-2.135	1.435-1.495	1.79
MS9518-10	.740-.760	.072-.120	.90	MS9518-30	2.240-2.260	1.560-1.620	1.87
MS9518-11	.802-.822	.122-.182	.94	MS9518-31	2.365-2.385	1.685-1.745	1.95
MS9518-12	.865-.885	.185-.245	.98	MS9518-32	2.490-2.510	1.810-1.870	2.03
MS9518-13	.928-.948	.248-.308	1.02	MS9518-33	2.615-2.635	1.935-1.995	2.11
MS9518-14	.990-1.010	.310-.370	1.07	MS9518-34	2.740-2.760	2.060-2.120	2.19
MS9518-15	1.052-1.072	.372-.432	1.11	MS9518-35	2.865-2.885	2.185-2.245	2.27
MS9518-16	1.115-1.135	.435-.495	1.15	MS9518-36	2.990-3.010	2.310-2.370	2.35
MS9518-17	1.178-1.198	.498-.558	1.19	MS9518-37	3.115-3.135	2.435-2.495	2.43
MS9518-18	1.240-1.260	.560-.620	1.23	MS9518-38	3.240-3.260	2.560-2.620	2.51
MS9518-19	1.302-1.322	.622-.682	1.27	MS9518-39	3.365-3.385	2.685-2.745	2.59
MS9518-20	1.365-1.385	.685-.745	1.31	MS9518-40	3.490-3.510	2.810-2.870	2.67
MS9518-21	1.428-1.448	.748-.808	1.35	MS9518-41	3.615-3.635	2.935-2.995	2.75
MS9518-22	1.490-1.510	.810-.870	1.39	MS9518-42	3.740-3.760	3.060-3.120	2.83
MS9518-23	1.552-1.572	.872-.932	1.43	MS9518-43	3.865-3.885	3.185-3.245	2.91

NOTES:

NOTICE

THIS DOCUMENT REFERENCES A PART WHICH CONTAINS CADMIUM AS A PLATING MATERIAL, CONSULT LOCAL OFFICIALS IF YOU HAVE QUESTIONS CONCERNING CADMIUM'S USE.

1. FOR PART NUMBERS MS9518-04 THRU MS9518-14 THE THREAD PD (DATUM "Z") SHALL REPLACE DATUM "Y".
2. MATERIAL: LOW ALLOY STEEL ~~AMS~~ 6322 (UNS G87400).
3. PROCUREMENT SPECIFICATION: AS7452.
4. HEAD TO SHANK FILLET RADIUS: FOR PART NUMBERS MS9518-13 AND LARGER, THE HEAD TO SHANK FILLET SHALL BE COLD ROLLED AFTER HEAT TREATMENT TO REMOVE ALL VISUAL EVIDENCE OF GRINDING OR TOOL MARKS.
5. FINISH: CADMIUM PLATE PER AMS 2400. DIMENSIONS ARE AFTER PLATING.
6. MAGNETIC PARTICLE INSPECTION PER ASTM E 1444.
7. INCOMPLETE THREADS NOT TO ENTER FILLET.
8. SURFACE TEXTURE: SYMBOLS PER ASME Y14.36M. REQUIREMENTS PER ASME B46.1. UNLESS OTHERWISE SPECIFIED, SURFACES TO BE 125 μ in Ra.
9. BREAK SHARP EDGES .003 TO .015, UNLESS OTHERWISE SPECIFIED.

SAE INTERNATIONAL®	AEROSPACE STANDARD	AS9518 SHEET 2 OF 3	REV. C
	BOLT, MACHINE - STEEL, CADMIUM PLATED, HEXAGON HEAD, UNS G87400, 125 KSI MIN, .1900-32 UNJF-3A		